

Date: Wednesday, 17/09/2008 3:52:42 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 42078	
Estimate Number : 13581	
P.O. Number :	Part Number : D38163
This Issue : 17/09/2008 S.O. No. :	Drawing Number : D3816 PREL <i>photo</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : PREL
Previous Run :	Material :
Written By : <i>Just 08.09.17.</i>	Due Date : 24/09/2008 Qty: 8 Um: Each
Checked & Approved By :	
Comment : Est Rev: A New Issue 08-09-17 JLM Verified By: EC	

Additional Product

FOR ENGINEERING USE ONLY

~~PRELIMINARY ISSUE~~

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0500 6061-T6 Round Bar .500"



Comment: Qty.: 0.0326 f(s)/Unit Total : 0.2604 f(s)

6061-T6 Round Bar .500"

Batch: *M107676**SA 08/09/21*

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA785 Rev: *N/A* & Dwg D3816 Rev: *A*

2-Deburr per dwg D3816

*SA 08/09/21**(10)*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SA 08/09/21**(10)*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*SA 08/09/21**(10)*

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SA**08-10-02**(X10)*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 42078

Part Number: D38163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



100

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. h

08/10/02

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

HARVEY

Identify and Stock

Location: _____

SS

08/10/03

(X)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.10.06

POSITIVE RECALL

EFFECTIVE 08.02.08

AUTH U

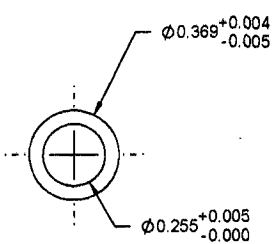
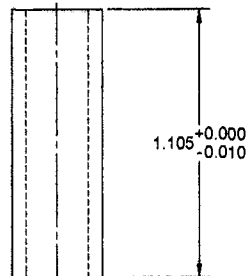
RELEASED

DATE

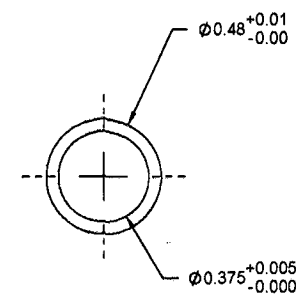
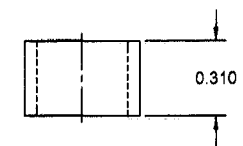
MA

002524

PRELIMINARY ISSUE



D3816-1 SPACER



D3816-3 SPACER

- NOTES:
- 1) MATERIAL: 3052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3816-1/-3 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3816-1 0.01 lbs
D3816-3 0.01 lbs

A	NEW ISSUE		08.09.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.11		

DART AEROSPACE LTD	REV. A
HAWKESBURY, ONTARIO, CANADA	SHEET 1 OF 1
DRAWING NO. D3816	SCALE
TITLE SPACER	NTS
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